

# A total solution to high performance adhesive bonding

## One stop shop technology for structural bonding of plastics

- **Fully comprehensive range of structural adhesives**

The Araldite® 2000 PLUS range adhesives for plastics can be used under a broad spectrum of processing and curing conditions and can meet the most demanding performance requirements. The range includes leading-edge epoxy, polyurethane and toughened acrylic technologies providing a complete solution to structural bonding.

- **Broad range of easy to use packing sizes**

Araldite® 2000 PLUS adhesives are available in a wide range of cartridge systems and small packs for convenient handling. These options allow the user to accurately deliver a measured quantity of adhesive with minimum wastage.

- **Local availability**

No matter where you are in the world, Huntsman's strong global network means Araldite® 2000 PLUS adhesives can be supplied locally. Our operations span 30 countries and are supported by an established worldwide distribution framework.

## Setting the industry standard for technical support

- **Comprehensive telephone technical support**

Huntsman sets the standard for technical support. Its industry experts can provide advice at a local level and can rapidly respond to customer challenges.

- **On site technical assistance**

Our network of technical support staff can give on site demonstrations and provide expert advice to find the best solution for a range of technical challenges.

- **Access to significant case history database**

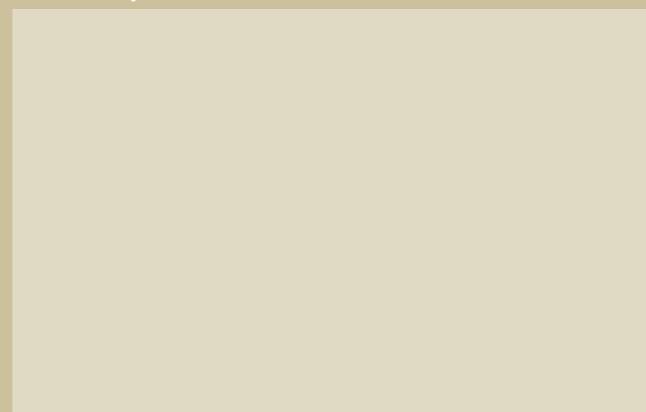
The Araldite® 2000 PLUS range can be used across a vast range of structural engineering applications. Sample case studies from our extensive library available on our website [www.araldite2000plus.com](http://www.araldite2000plus.com).

- **Additional reference guides available**

Araldite® has been a leading adhesive brand for 60 years and our experience is reflected in our comprehensive technical support packages which can be accessed through our website and provide a complete solution to all adhesive processing and performance needs.



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[www.araldite2000plus.com](http://www.araldite2000plus.com)

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Enriching lives through innovation

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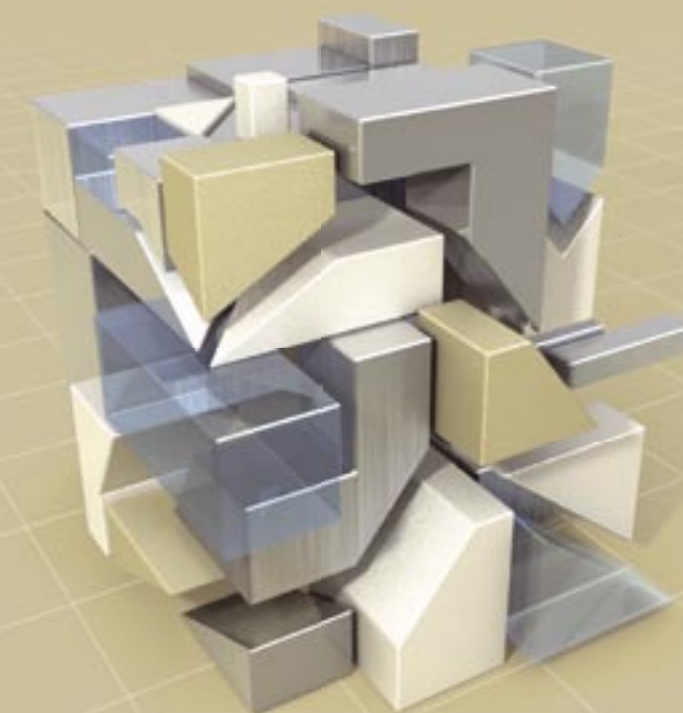
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Design: [www.zygmund.fr](http://www.zygmund.fr)

# Araldite® 2000+

Strength in bonding

bonding **plastics**  
to metals and dissimilar substrates



# HUNTSMAN

Enriching lives through innovation

The appropriate solution for

# Bonding plastics to any substrates

Huntsman's recognised expertise in research and development allows us to offer a uniquely wide range of innovative solutions all of which are backed by strong technical support and excellent levels of customer service. Araldite® 2000 PLUS adhesives are designed to satisfy all your plastic bonding requirements.

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
<b>Chemical type</b>	Multi purpose	Rapid cure		Chemical / temperature resistance		Toughened			Flexible			Rigid
<b>Fast curing</b>	EP	EP	EP	EP	EP	EP	MMA	MMA	PUR	PUR	PUR	PUR
<b>Gap filling</b>		■	■			■	■	■	■	■	■	■

## BONDING PLASTICS TO PLASTICS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
GRP	●	○	●	●	●	●	●	●	●	●	●	●
CFP	●	●	●	●	●	●	●	●	○	○	●	○
SMC	●	○	○	●	●	●	○	○	●	○	●	●
ABS	●	○	○	○	○	○	○	●	●	○	●	●
PVC	○	○	○	○	○	○	●	●	○	○	○	●
PMMA	○	○	○	○	○	●	●	●	○	○	●	○
Polycarbonate	○	○	○	○	○	○	●	●	●	●	●	○
Polyamides	●	○	○	○	○	○	●	○	○	○	●	○

## BONDING PLASTICS TO METALS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Ferrous metals	●	○	●	●	●	●	●	●	○	○	○	○
Stainless steel	●	●	●	●	●	●	●	●	○	○	○	●
Aluminium	●	●	●	●	●	●	●	●	○	○	○	●
Copper	●	●	●	●	●	●	●	○	○	○	○	●
Brass	●	●	●	●	●	●	●	○	○	○	○	○
Zinc / Galvanised metal	●	●	○	●	●	○	○	●	○	○	○	●

## BONDING PLASTICS TO NON METALS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Rubbers	○	○	○	○	○	○	○	○	○	○	○	○
Glass	○	○	○	○	○	○	○	○	○	○	○	○
Ceramics	●	○	●	●	○	○	●	●	○	○	○	○
Wood	●	●	●	●	●	●	○	○	●	○	●	●

EP Epoxy / MMA Methyl Methacrylate / PUR Polyurethane / ● Excellent / ○ Good / ○ Moderate



# Processing, performance and packaging data

Araldite® 2000 PLUS is a trusted brand – with more than 60 years experience in developing engineering adhesives.



Bonding plastics	Multi purpose	Rapid cure		Chemical / temperature resistance		Toughened			Flexible			Rigid
	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
<b>Chemical type</b>	EP	EP	EP	EP	EP	EP	MMA	MMA	PUR	PUR	PUR	PUR
<b>Product description</b>	<ul style="list-style-type: none"> <li>Multi purpose</li> <li>Long working life</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Fast curing</li> <li>Toughened</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Fast curing</li> <li>General purpose</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Metal coloured paste</li> <li>Suitable for vertical applications</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Grey paste</li> <li>High temperature and chemical resistance</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Toughened paste</li> <li>Ideal for GRP, SMC and dissimilar substrates</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Rapid curing</li> <li>High peel strength</li> <li>Multi purpose</li> </ul>	<ul style="list-style-type: none"> <li>Good sanding properties</li> <li>Ideal for bonding thermoplastics</li> </ul>	<ul style="list-style-type: none"> <li>Good UV stability</li> <li>Ideal for bonding thermoplastics</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Ideal for bonding plastics</li> <li>Low shrinkage</li> <li>Ideal for thick bond lines</li> </ul>	<ul style="list-style-type: none"> <li>Rapid cure</li> <li>Black colour</li> <li>Ideal for bonding plastics especially SMC &amp; polyamides</li> <li>Low shrinkage</li> </ul>	<ul style="list-style-type: none"> <li>Gap filling</li> <li>Long open time</li> <li>Resists weathering and humidity</li> <li>Low shrinkage</li> </ul>

## PROCESSING DATA

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
<b>Viscosity (at 73°F)</b>	30k-45k cps	Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Appr. 8k cps	Appr. 50k cps	Appr. 55k cps	Thixotropic
<b>Useable life of adhesive (at 73°F)</b>												
<i>In mixer nozzle</i>	1.8 hr	10 min	8 min	1.3 hr	1 hr	40 min	3 min	10 min	40 min	15 min	15 min	45 min
<i>100 g (0.22 lb) of mix</i>	1.5 hr	6 min	5 min	60 min	1 hr	40 min	-	-	40 min	15 min	15 min	60 min
<b>Time required to reach (at 73°F)</b>												
<i>Light handling strength (145 psi)</i>	7 hr	30 min	20 min	4 hr	3 hr	4 hr	8 min	18 min	4 hr	6 hr	3 hr	6 hr
<i>50% of final shear strength</i>	10 hr	3 hr	1 hr	10 hr	5 hr	6 hr	20 min	30 min	16 hr	20 hr	16 hr	20 hr
<b>Time required to reach (at 140°F)</b>												
<i>50% of final shear strength</i>	45 min	20 min	10 min	40 min	20 min	40 min	-	-	30 min	1.5 hr	60 min	60 min

## PERFORMANCE DATA

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
<b>Lap shear strength on GRP substrate</b>	1640 psi	725 psi	1335 psi	1200 psi	1250 psi	1335 psi	1130 psi	1130 psi	1160 psi	1090 psi	1150 psi	1305 psi
<b>Peel strength on Al substrate</b>	28 pli	34 pli	31 pli	22 pli	17 pli	23 pli	62 pli	22 pli	22 pli	22 pli	34 pli	6 pli
<b>Typical Tg / max temp giving LSS of 725 psi</b>	113°F / 194°F	104°F / 176°F	104°F / 176°F	113°F / 158°F	185°F / 266°F	149°F / 230°F	149°F / 230°F	113°F / 212°F	Flex / 104°F	86°F / 122°F	86°F / 122°F	140°F / 194°F
<b>Resistance properties</b>												
<i>Chemical</i>	○	○	○	●	●	○	○	●	○	○	○	○
<i>Heat</i>	○	○	○	○	○	○	○	○	○	○	○	○
<i>Water</i>	○	○	○	○	○	○	○	○	○	○	○	○
<i>Impact</i>	●	●	○	○	○	○	○	○	○	○	○	○

## PACKAGING

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
<b>Cartridges</b>												
<i>50 ml</i>	■	■	■	■	■	■	■	■				
<i>200 ml</i>	■	■	■	■	■	■	■	■	■			
<i>400 ml</i>				■			■	■		■		■
<i>500 ml</i>												
<b>Working packs (1.8 kg (4 lb) kits)</b>	■		■	■	■	■						